

Step July 30

Dart Aerospace Ltd.

31

Date: Wednesday, 7/11/2007 2:45:59 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number : 33463	
Estimate Number : 10824	
P.O. Number : <i>N/A</i>	Part Number : D412630032
This Issue : 7/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : D412-630 REV. A <i>P17</i> K PG. 19
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : <i>JK</i>
Previous Run : 32082	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/31/2007
Checked & Approved By : <i>[Signature]</i> 07.07.11	Qty: <i>2</i> Um: Each
Comment : EST. REV. A 05.11.21 NEW ISSUE EC	
EST. REV. B 05.12.19 updated pick list EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

KS 07-07-25

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 ~~17~~

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

MF 07-07-26

3.0	D3463042	Step Weldment
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	

B29670

x 2mx

MF 07-07-26

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3443-043	Strut ass'y

Batch

B 29672 x 1mx, B 28524 x 1mx.

B 29672 x 1mx

MF 07-07-26

5.0	D3443041	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3443-041	Strut ass'y

Batch

B 29671 x 1mx

B 29671

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D34439

PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D3443-9 Pin

B30228

MF 07-07-26

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 AN4CH3 BOLT
A/R MS20995c41e Lockwire

m103248
m101537

MF 07-07-26

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 AN4C14 BOLT

m103248

MF 07-07-26

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D3454-7 Bushing

B30225

MF 07-07-26

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 AN310-4 Nut

m103641

MF 07-07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	MS24665-227	COTTER PIN

Batch

m102013

MF 07-07-26

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	<u>B28171</u>

MF 07-07-26

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	<u>B30308</u>

MF 07-07-26

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	<u>m103286</u>

MF 07-07-26

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	<u>m16941</u>

MF 07-07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



JAA-30 (2)



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3454-1	Bushing

Batch

33730

✓ SP

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-3	Bushing

Batch

1228531

✓ (3) 130223 SP

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-5	Bushing

Batch

130224

✓ (3) 28533 SP

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description
6	D3455-1	Spacer

Batch

122871

✓ 7/1/25 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	B28172

✓ SP

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-042	Bracket ass'y	28492

* SP 33479 ✓

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	M105057

SP ✓

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	M102073

SP ✓

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	M100186

SP ✓

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
			7/7/25 SP

105161

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

1

AN44-C12

Eyebolt

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	M103248

SP ✓

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	M103248

✓ SP

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	M104395

✓ SP

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total: 21.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	M101069

✓ SP

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	M17697

✓ 7/2/25 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 7/11/2007 2:46:00 PM
User: Kim Johnston

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description

Batch

6.1 3 MS21043-3 Nut

M104679 ✓ SQ

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS24665-227

COTTER PIN

M102073 ✓ SQ

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS24665-229

COTTER PIN

M19096 ✓ SQ

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 NAS1515H5

Washer

M105057 ✓ 2/7/25 SQ

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

4 07-07-20 2012/30 (2)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

A 7/7/30 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 33463

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

ED 07/07/31

Job Completion



u 07-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

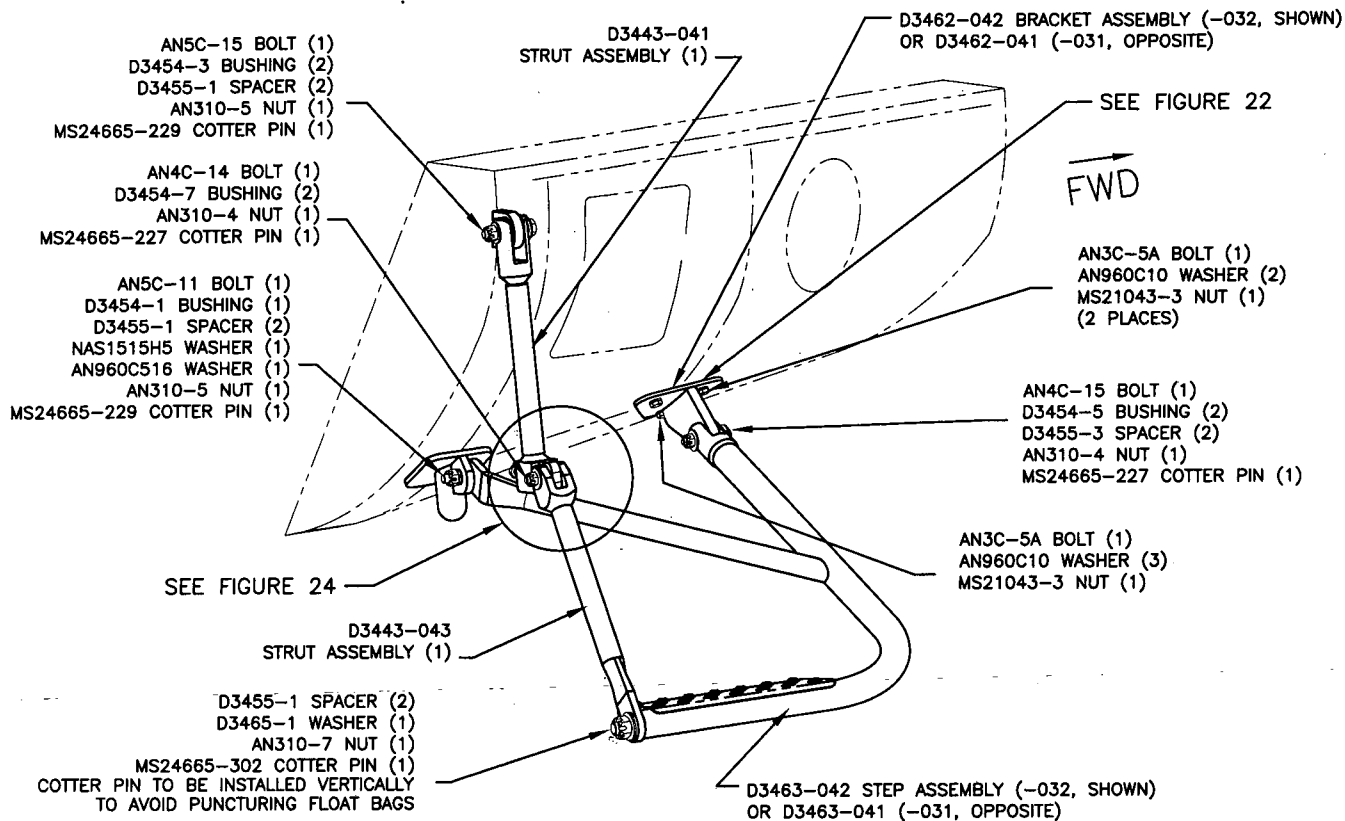
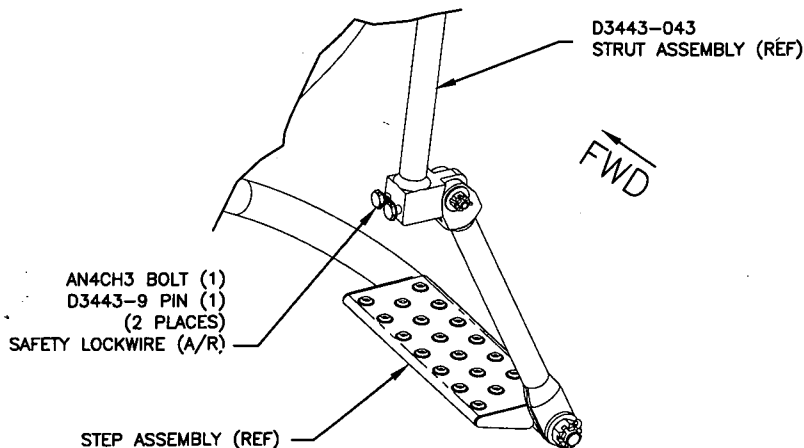


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33463